



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 71389

Thursday, June 30, 2011 11:41:49 AM



Page 2

Item ID: D2322

Accept



Setup Start



Revision ID:

Stop



Item Name: Step Spacer

Start Date: 6/30/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 7/5/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  Brake NC	NC BRAKE	0.00				(22)			
Brake NC	Memo Form as per Dwg D2322	0.00							
140  QC	QC5- Inspect part completeness to step on W/O	0.00							
Quality Control	Memo	0.00							
150  HandFinish	Chemical Conversion Coat per QSI005 4.1	0.00							
Hand Finishing	Memo	0.00							

SB 6/27/28

11 07 28 (22)

22 6/27/28

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**Work Order ID 71389**

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Page 3

Item ID: D2322

Accept



Setup Start



Revision ID:

Stop



Item Name: Step Spacer

Start Date: 6/30/2011 Start Qty: 12.00



Cust Item ID:

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Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 	QC3- Inspect Part Finish	0.00							
QC Quality Control	Memo	0.00				22	6	11/07/28	
170 	Identify as per dwg & Stock Location	0.00							
Packaging Packaging	Memo	0.00				22		11/7/28	
180 	QC21- Final Inspection - Work Order Release	0.00							
QC Quality Control	Memo	0.00						11/7/29	

11/07/28  
28

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**NOTE:** Date & initial all entries

# Picklist Print

Thursday, June 30, 2011 11:41:55 AM

Page 1

Work Order ID: 71389



Parent Item: D2322

Parent Item Name: Step Spacer

Start Date: 6/30/2011

Required Date: 7/5/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A New Issue 05-11-07 JLM  
IPP Rev:B Now on Waterjet 06-07-03 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.040		Purchased		No		100	sf	202.5684	0.203	2.564211			

2024-T3 .040 sheet

Location

Loc Qty

Loc Code

MAT022

202.568421

112291

0.5

112331

0.7

113162

18.1

117684

183.268421

5.0 ~~9.0~~ 11/07/27

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DESIGN	DRAWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	REV. C
BW	CP		
CHECKED KE	APPROVED [Signature]	DRAWING NO. D2322	SHEET 1 OF 1
DATE 98.09.29	TITLE STEP SPACER	SCALE 1:2	
A	94.10.14	NEW ISSUE	
C	98.09.29	4.428 WAS 4.460, 0.040 WAS 0.032 CHANGES PER NCR 001	

RELEASED  
18.10.08 DS

UNDER REVIEW

01.03.15 CP

DESIGN OK, BUT CHECK WITH  
DJS BEFORE MANUFACTURE

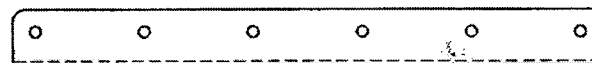
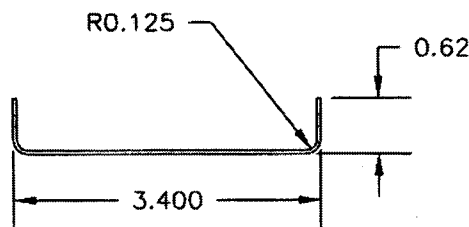
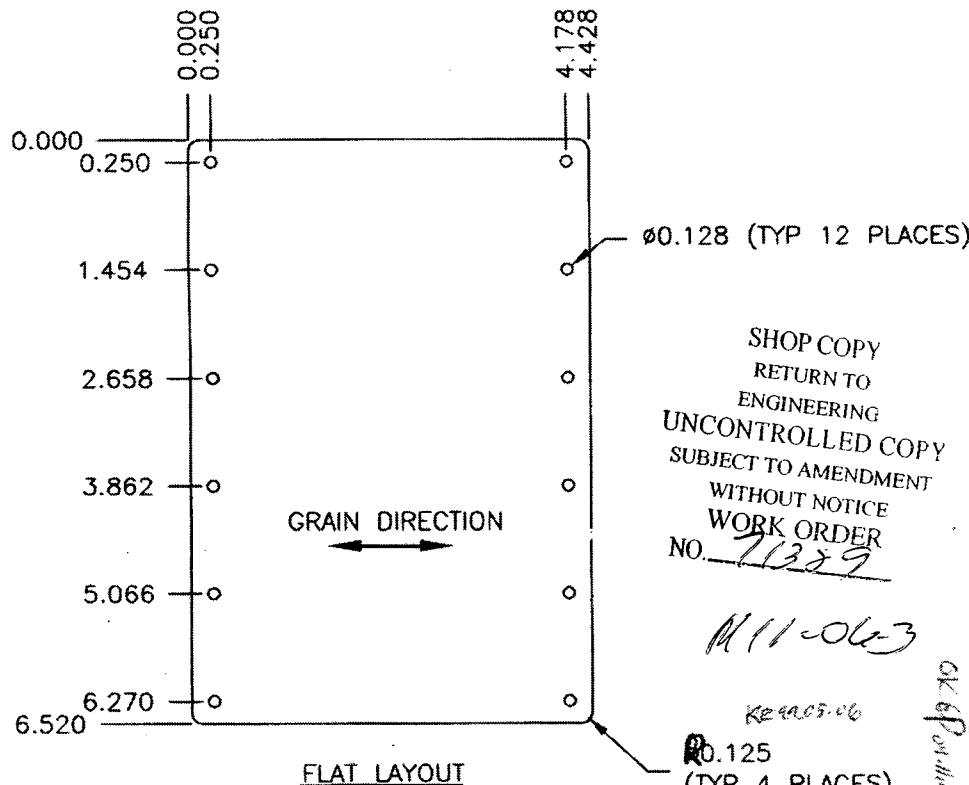
OK BP on 11/11

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 71329

1111-063

KE 98.09.06

R0.125  
(TYP 4 PLACES)



MATERIAL: 2024-T3 (QQ-A-250/5) 0.040 THICK  
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1  
TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

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